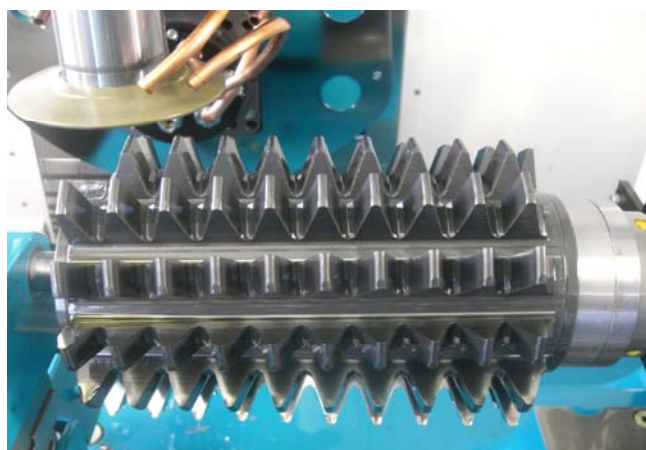


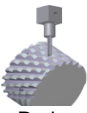

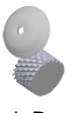




## Gear Hob Ø125 Z14

A12-020

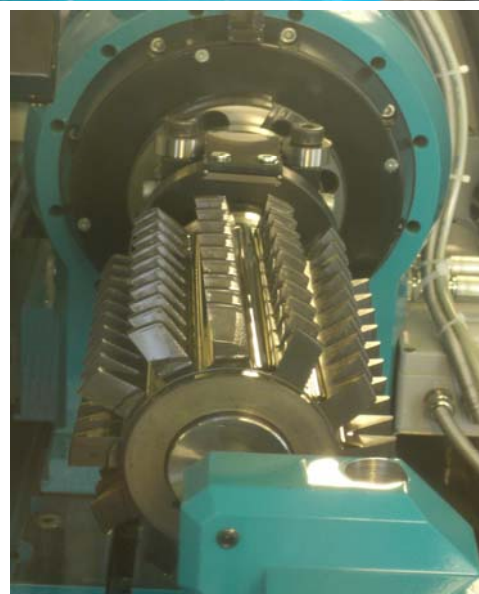
The specified cycle guarantees an excellent surface finishing ( $R_a$  less than 0,2) and the grinding operation itself leads to the best results in terms of geometric requirements such as rake angle, rake offset, indexing and helix, all of which can be easily checked without unclamping the part by mean of the in-built 3D probe



### 1. Cycletime for Resharpener

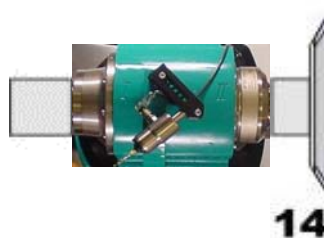
Tool specifications				
Ø70 mm, Z20, Grinding Length 200 mm, Gash Lead Angle 3.5°				
Material HSS				
Operations				
Feed [mm/Min]	2000	100	2000	1000
Power [kW]		4	2	2
Cutting feed [m/s]		12	36	36
Used wheels				
Grinding time [s]	139	144	393	273
Total cycle time	15 Min 48			

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.



### 2. Used Grinding Wheels

14	1V1 Ø150 B76
----	--------------



### 3. Machine and Software Requirements

Machines: 5 axes CNC grinders : GEMINI DMR, Dressing Unit (Diamond Metalbonding), A-Rapid  
 Control: Fanuc 31i  
 Coolant: Synthetic Oil, pressure 6 bar  
 Software: Quinto 5

responsible engineer: OP,9.4.09

[www.schneeberger.ch](http://www.schneeberger.ch)

J. SCHNEEBERGER Maschinen AG 4914 Roggwil Switzerland  
 Subsidiaries in: France, Deutschland, Italia, United States, China

TECHNOLOGY  
FOR TOOLING